



PATENT

IN THE UNITED STATES PATENT  
AND TRADEMARK OFFICE

Applicant: Michael E. Rakauskas )  
Serial No.: 09/309,130 )  
Filed: May 10, 1999 )  
Title: LOW PRESSURE )  
MELAMINE/VENEER PANEL )  
Group Art Unit: 1773 )  
Examiner: Kevin R. Kruer )  
Attorney Docket #: 28572/32531A )

*Will  
to be  
Chris*

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**DECLARATION OF MICHAEL E. RAKAUSKUS**  
**UNDER 37 C.F.R. § 1.131**

Commissioner for Patents  
Washington, D.C. 20231

I, Michael E. Rakauskus, hereby state as follows:

1. I am the named inventor of the above-identified patent application.
2. Attached hereto is a document dated prior to February 7, 1997. The attached document has been redacted to omit dates.
3. The attached document is an invention disclosure form that I prepared at International Paper's facilities in Oshkosh, Wisconsin. This document has been maintained as a business record in the normal course of business.
4. The attached document describes the preparation and testing of a laminated composite wood product in the United States prior to February 7, 1997. As set forth in this document, this product comprises a rigid substrate layer having two substantially flat sides, a resin-saturated sheet layer (i.e., a "LPL sheet") on each of said substantially flat sides, and a veneer layer on only one of said sheet layers.
5. The attached document also describes methods of making the wood product. Specifically, as set forth in this document, one such method includes subjecting a layered

structure to elevated temperature and pressure in a pressing apparatus for a time sufficient to cure the resin in the resin sheet layer at this temperature and pressure.

6. The methods described in the attached document also include methods wherein the pressing apparatus includes a first platen and a second platen, the first platen operating at a temperature different from the operating temperature of the second platen.

7. The attached document further demonstrates the successful reduction to practice of the laminated composite wood product and methods for its manufacture as recited in the claims of my above-identified patent application prior to February 7, 1997, in the United States.

8. I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under 18 U.S.C. § 1001 and that such willful false statements may jeopardize the validity of the above-identified application or any patent issued thereon.

Date 5/25/01, 2001

By: Michael E. Rakauskas  
Michael E. Rakauskas

Post-It <sup>®</sup> brand fax transmittal memo 7671		# of pages	2
To	M. DOYLE		
From	R. O'DELL		
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 IAL  PAPER  
 ITS DIVISION

IP 5309

Idea No. P95-01

Print or type: extra sheets may be attached but must be signed, dated and witnessed as on reverse of this sheet.  
 Title of Idea:

## METHOD TO PRODUCE A LOW PRESSURE MELAMINE/VENEER PANEL

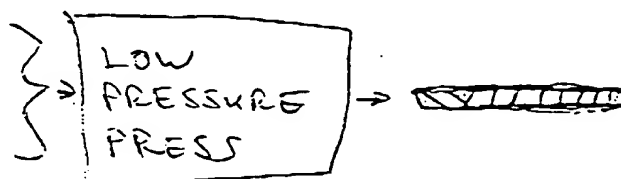
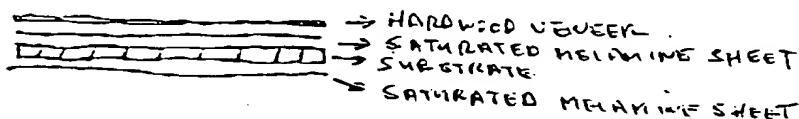
Brief Statement of Idea:

UTILIZE A SHEET OF LOW PRESSURE MELAMINE SATURATED PAPER AS A DRY GLUE LINE TO THERMALLY FUSE A WOOD VENEER TO PARTICLEBOARD OR MEDIUM DENSITY FIBERBOARD WHILE SIMULTANEOUSLY LAMINATING ANOTHER DECORATIVE LPL SHEET TO THE OTHER SURFACE OF THE PANEL.

State the problem intended to be solved, attempted solutions by others, and your solution. Cite literature and patents that you have read in connection with this problem. Give any unexpected results of your solution.

AROUND BILL DECKER, THEN THE TECH. MGR. AT PLUSWOOD, ATTEMPTS WERE MADE TO PRODUCE A LPL/VENEER PANEL. THE HARDWOOD VENEER WAS APPLIED FIRST IN A CONVENTIONAL HARDWOOD VENEER PRESS AND USING A WET UF ADHESIVE. THIS PANEL WAS THEN LAMINATED WITH A SATURATED DECORATIVE MELAMINE SHEET IN A LOW PRESSURE PRESS. RESULTANT PANELS WERE UNSATISFACTORY DUE TO EXCESSIVE WARPAGE TOWARD THE VENEER SIDE. BY UTILIZING A LPL SHEET AS ~~A~~ A DRY GLUE LINE AND SIMULTANEOUSLY LAMINATING A LPL SHEET TO THE PANEL'S OTHER SIDE, MINIMAL MOISTURE IS INTRODUCED TO THE PANEL. BY CONTROLLING THE CURVE OF EACH SIDE VIA TEMPERATURE ADJUSTMENTS, A FLAT PANEL IS OBTAINED.

Give a detailed description and/or illustration of a specific embodiment of the invention. Also give operable ranges for conditions and alternatives for materials. Please use descriptive names for materials and apparatus rather than trademarks or supplier's product designations.



### PRESS TEMP. RANGE

TOP PLATEN: 350°F - 405°F

BOTTOM PLATEN: 320°F - 350°F

### CURE TIME RANGE: 30-40 seconds

### PRESSURE RANGE:

325psi TO 425psi

### BASIS WEIGHT OF LPL PAPERS:

80gm/m<sup>2</sup> - 150gm/m<sup>2</sup>

### HARDWOOD VENEERS:

ROTARY CUT & SLICES OAK  
 MAPLE  
 BIRCH  
 PINE  
 CHERRY  
 HICKORY  
 PECAN  
 ETC.

### ALTERNATE MATERIALS

HPL  
 MAN-MADE VENEER  
 (GATORPLY)

### SATURATION RESINS:

60:40% Melamine/Urea BLEND  
 100% MELAMINE

Date on which I (we) first thought of this idea:

Date of first disclosure of idea:

Identify first written disclosure (e.g., laboratory notebook page or other): NOTEBOOK MR95 PAGE 1

Date:

Date of first drawings:


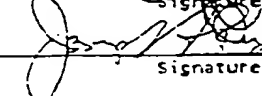
When was the idea first tried?

By whom? MIKE PRIEBEWitnesses: GREG POTRATZWhere recorded? FLUSHWOOD TRIAL BRIEF # 196

Other pertinent laboratory notebook pages or reports:

LAB NOTEBOOK MR-95  
PAGES 1-6Has this invention been disclosed to others outside the company; has the product been sold? NO, NO.  
If yes, give date:Give date of anticipated disclosure or sale: TBDFOLLOWING ADDITIONAL EVALUATIONSINVENTOR(S)Full Name:  
Citizenship:MICHAEL EDWARD RAKAUSKAS  
U.S.Residence:  
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Mail No.  
Dept., Div., Subsidiary  
City, State  
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DESCRIPTIVE PRODUCTS  
OSHKOSH, WI.  
(414) 235-0440Signature:  
Date:Michael E. RakauskasWITNESSES

I hereby affirm that I understand the invention set forth in this disclosure and the principle thereof.

  
Signature of Witness  
  
Signature of Witness

Date

Date

